

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017947**Date Inspected:** 21-Oct-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu tao**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, S.Chandrakumar was present during the times noted above for observations relative to the work being performed.

BAY#19

FCAW welding of weld is identified as 2G-090 of BK004A6-006 for BK004A-006. The welder is identified as 062762. ZPMC QC is identified as Mr. Xu tao. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2332-Tc-P4-F.

FCAW welding of weld is identified as 3G-092 of BK004A8-006 for BK004A-006. The welder is identified as 208641. ZPMC QC is identified as Mr. Liu dao feng. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2333-Tc-P4-F.

FCAW welding of weld is identified as 4G-098 of BK004A6-006 for BK004A-006. The welder is identified as 058792. ZPMC QC is identified as Mr. Liu dao feng. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2334-Tc-P4-F.

FCAW welding of critical repair weld is identified as 1G-017 of BK004A2-011 for BK004A-011. The welder is identified as 202338. ZPMC QC is identified as Mr. Liu dao feng. The welding variables recorded by QC are appeared to comply with the WPS-345-SMAW-1G(1F)-Repair and B-CWR2070.

ZPMC QC NDT personnel performing MT of plug welds in bike path BK004A-001 is in progress.

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During Visual inspection it is found that fit-up of anchor housing pipe is identified as BKX10J in bike path BK004A-004, there is gap of approximately 3mm found in between deck plate and pipe. This is informed to ABF QA Mr. Peter shaw for further action. For more information please see the attached photos.

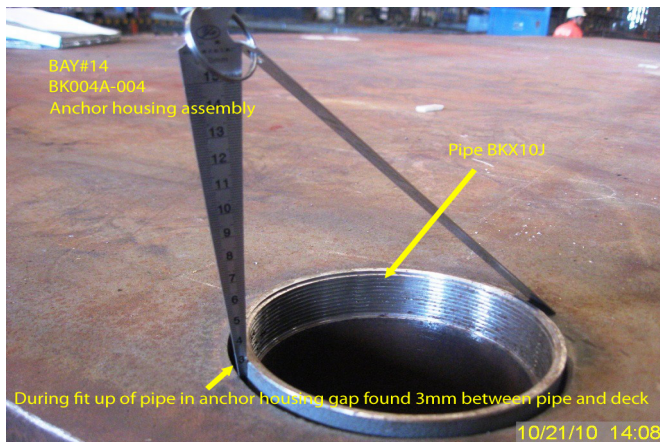
This QA inspector performed MT 15% of weld areas previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated an MT report for this date. The members are identified as OBG Bike path. The weld designations reviewed as follows.

BK005A1-001-016,017,019,024,027

BK005A6-001-001,002,007,165

BK005A8-001-001,002,007,130

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



## Summary of Conversations:

No relevant Conversation.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang-15--0042-2372, who represents the Office of Structural Materials for

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your project.

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<b>Inspected By:</b>	Kumar,Chadra	Quality Assurance Inspector
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<b>Reviewed By:</b>	McClendon,Timothy	QA Reviewer
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